

Work Order ID 70833

Wednesday, June 15, 2011 3:59:12 PM

Page 1

Item ID: D2330-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Basket Lid Assembly

Start Date: 6/21/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 6/29/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: MMK Date: 11-06-15 Tooling:

Date:

Run Start

QC: Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2330	Rev H
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100		0.00
-----	--	------



Large Fab

Large Fab

Memo

0.00

Large Fab

1- Cut D2330-1-3-9 as per Dwg D2330
2-Drill hole in D2330-3 as per Dwg D2330
3-Deburr

11.06.21

110		0.00
-----	--	------



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D2330 using Welding Table and corner Jig
Deburr as required
A/R SS ROD Batch: 1115278

11.06.22

120		0.00
-----	--	------



QC9- Inspect visual per QS1004- Fusion Welds

QC

Memo

0.00

Quality Control

11.06.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70833

Wednesday, June 15, 2011 3:59:13 PM



Page 2

Item ID:	D2330-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Lid Assembly					
Start Date:	6/21/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	6/29/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

135	Pressure Wash per QSI005 4.3	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating									

START TIME: 10:45
OVEN TEMPERATURE: 400 OF
FINISH TIME: 11:15

1st coat
Start Time: 11:15
Temp: 400 OF
Finish Time: 11:45
2nd coat

1 X Ø M-11/06/23

1 X Ø M-11/06/23

1 X Ø M-11/06/23

M116964

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 6/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							1 6 14 1106/23
160 Packaging Packaging	Identify as per dwg & Stock Location: <i>GA</i> Memo <i>W/O 70832</i>	0.00 0.00							<i>ES 11/06/23</i>
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>11/6/27</i> <i>ME</i> <i>11-06-23</i>

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Picklist Print

Wednesday, June 15, 2011 3:59:04 PM

Page 1

Work Order ID: 70833

Parent Item: D2330-043

Parent Item Name: Basket Lid Assembly

Start Date: 6/21/2011

Required Date: 6/29/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S KJ
IPP Rev:I 08-09-09 revF as per dwg (ecn 08-522) DD verf:EC
IPP REV:J 10.11.30 AS PER DWG REV.H DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2252-1 Frame		Manufactured	No			100	Each	16.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA006				16					
				51941				8					
				58084				8					
✓ D2252-7 Frame		Manufactured	No			100	Each	5.0000	4	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA006				5					
				48324				1					
				61960				4					
✓ D2327-3 Spacer Bushing		Manufactured	No			100	Each	10.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				10					
				70724				10					
✓ D2329 Label Plate		Manufactured	No			100	Each	5.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA006				5					
				40488				5					

SAD 11-06-20

SAD 11-06-20

SAD 11-06-20

SAD 11-06-20

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Wednesday, June 15, 2011 3:59:05 PM

Page 2

Work Order ID: 70833

Parent Item: D2330-043

Parent Item Name: Basket Lid Assembly

Start Date: 6/21/2011

Required Date: 6/29/2011

Start Qty: 1.00

Required Qty: 1.00

D2330-1

Manufactured No

100

Each

4.0000

2

2



Frame



SAD 11-06-20

Location

Loc Qty

Loc Code

WA006

4

61931

4

2

D2330-15

Manufactured No

100

Each

0.0000

1

1



Frame



SAD 11-06-20

D2581

Manufactured No

100

Each

74.0000

2

2



Mounting Bracket



SAD 11-06-20

Location

Loc Qty

Loc Code

WA

74

68964

6

69258

28

69739

40

2

D3749-1

Manufactured No

100

Each

18.0000

3

3



Hinge Half



SAD 11-06-20

Location

Loc Qty

Loc Code

WA

18

70063

18

3

Wednesday, June 15, 2011 3:59:05 PM

Shop Packet Print

Page 2

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Page 3

Work Order ID: 70833

Parent Item: D2330-043

Parent Item Name: Basket Lid Assembly



Start Date: 6/21/2011

Required Date: 6/29/2011

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

611.1169

18.9

18.9



Expanded Metal Flat SS



6/21/06-22

Location

Loc Qty

Loc Code

MAT

38.2107

117708

38.2107

WA

572.9062

115012

102

117197

134.8721

117455

16.0341

117896

320

117896

18.9

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ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

H	DIM 0.50 WAS 0.75 (ZN D2-3 & D6-3) REF NCR 10-346	JPH	10.09.28
G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/-3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/-9/-13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	JL	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JL	DRAWING NO.	REV. H
MFG. APPR.	JL	D2330	SHEET 1 OF 6
APPROVED	JL	TITLE	SCALE
DE APPR.	JL	BASKET ASSEMBLY (206B)	NTS
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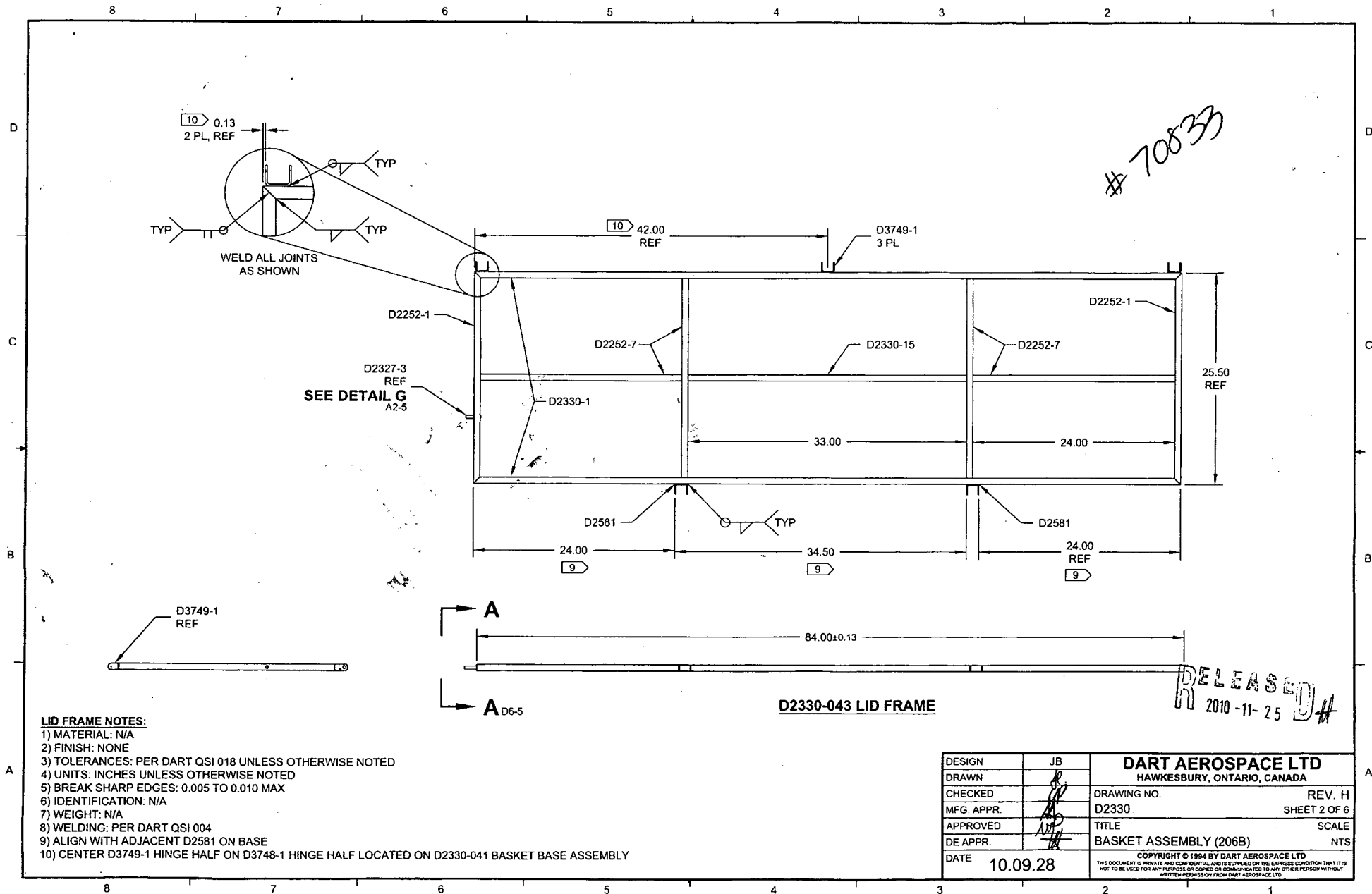
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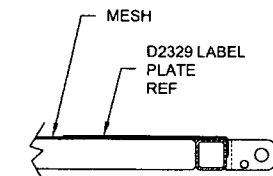
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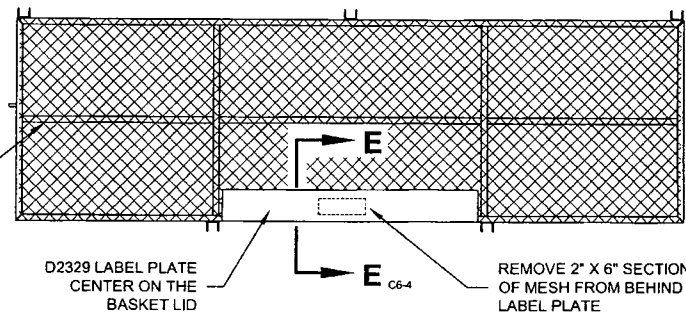
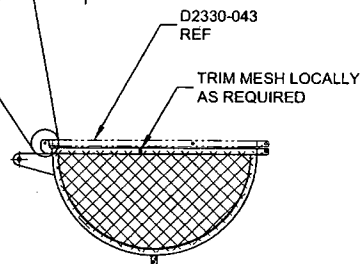
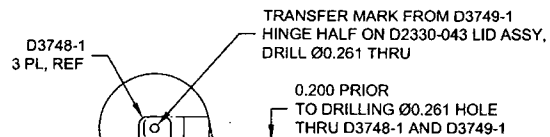
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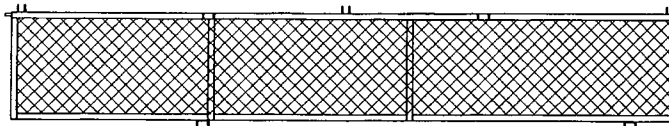
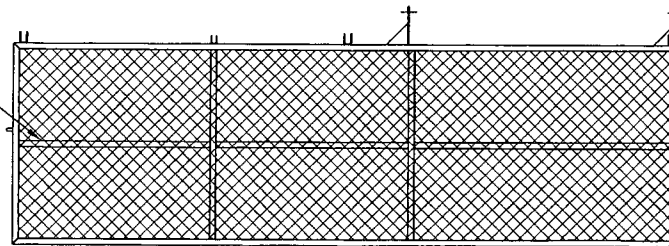


SECTION E-E C3-4
VIEW ROTATED 90° CCW

TACK WELD EACH
STRAND END OF
MESH TO FRAME






D2330-043 LID ASSEMBLY



D2330-041 BASE ASSEMBLY

ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NT
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70833

RELEASED
2010-11-25

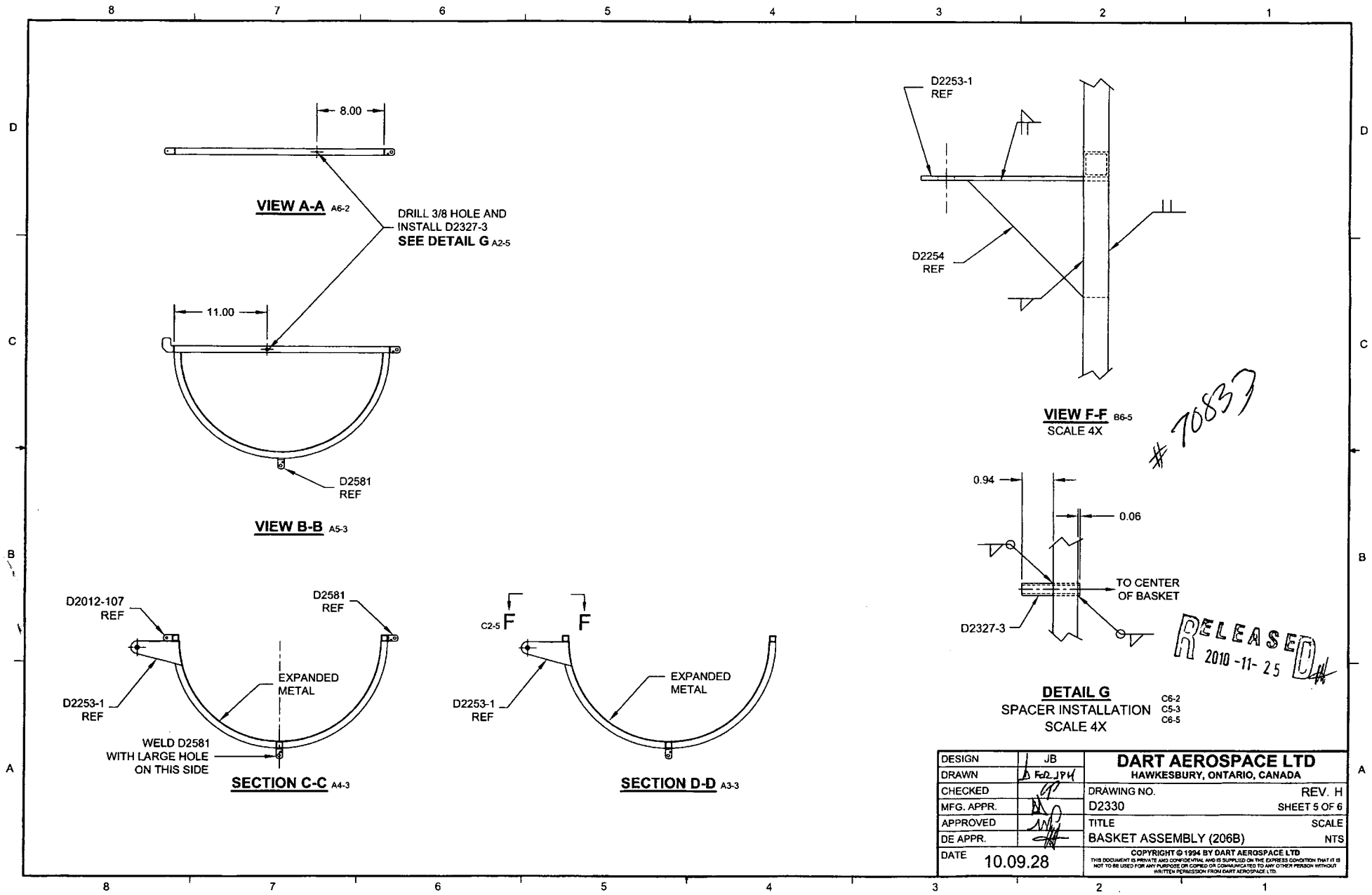
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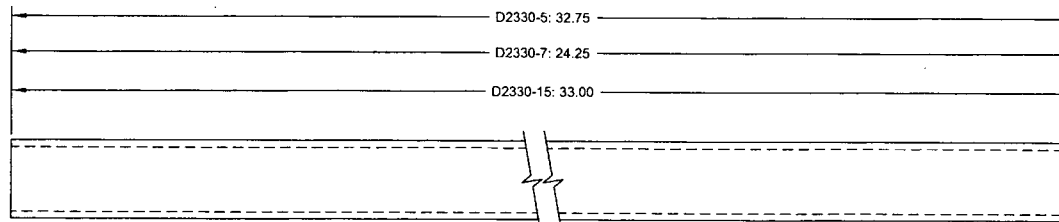
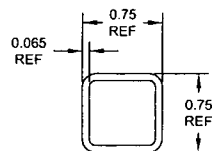
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8 7 6 5 4 3 2 1

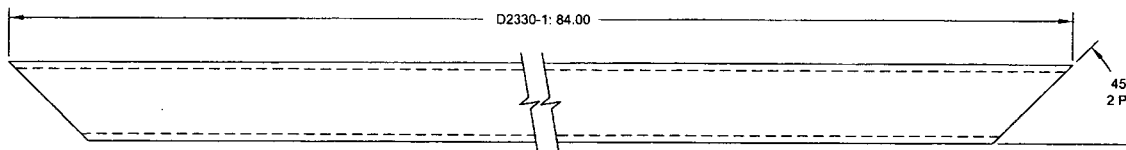
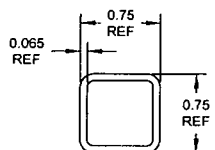
D



D2330-5 FRAME
D2330-7 FRAME
D2330-15 FRAME

C

#70833



D2330-1 FRAME

B

RELEASED
2010-11-25

A

- NOTES:**
1) FRAME MATERIAL: SEE SHEET 1
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

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A

8 7 6 5 4 3 2 1

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